

Abstract

A one-piece molded polymeric sight gauge shield with internal cylindrical bore and method for making same are disclosed, along with a liquid-containing urn including same. The shield is molded by mating first and second mold portions about first and second spaced-apart cores to define: (i) a first annular void about the first core; and, (ii) a second annular void about the second core. The first and second mold portions respectively comprise first and second stand-up portions that first and second sidewall voids between themselves and the mating mold portion. First and second end portions of a gauge shield member are molded by filling the first and second voids, while the first and second sidewalls of the gauge shield member are molded by filling the first and second sidewall voids. The molding operation is a single-axis straight-pull molding method.